



Dart Aerospace Ltd.
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D3913-041
Job Sheet 207337



Part No: D3913-041

Job Qty: 1 pcs

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/25/20

Job Tracking No:

Due Date: 3/31/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	3/31/20		0.00	19.61	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		DAS
							Large Fab - 6		43
							Large Fab - 7		9-89
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	1 pcs	3/31/20		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		DAS
							QC 9 - 43		24
							QC 9 - 50		9-89
							QC 9 - 9		
120	QC 5	1 pcs	3/31/20		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		DAS
							QC 5 - 19		24
							QC 5 - 22		9-89
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		



Container No: S267005



Part: D3913-041

Job No: 207337

Serial No/Batch: S267005

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 03/27/20

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					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
125	Handfinish - 2-1 Pressure-B4B	1 pcs	3/31/20	0.00 0.29	Handfinish - 2 - 1 - B4B	
					Handfinish - 2 - 2 - B4B	
					Handfinish - 2 - 3 - B4B	20-04-7
					Handfinish - 2 - 4 - B4B	
130	Powdercoat - 2 White Gl(S)-B4B <i>M 254469</i>	1 pcs	3/31/20	0.00 0.93	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	20-04-7
					Powdercoat - 4 - B4B	
140	QC 3	1 pcs	3/31/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	M 20-4-7
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
150	Handfinish - 4-1-Assembly-B4B	1 pcs	3/31/20	0.00 0.50	Handfinish - 4 - 1 - B4B	M 20-4-8
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 -	

DAS 34 9-89

DAS 34 9-89

DAS 15 9-89

				B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
160 QC 5	1 pcs	3/31/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	APR 08 2020 40
				QC 5 - 61	8-89
				QC 5 - 81	
170 Packaging 3-1 - Stock - B4B	1 pcs	3/31/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	ML 70-4-P8
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	

					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
180 QC 21 - SA	1	3/31/20	0.00	0.00	QC 21 - SA - 21	DAS
	pcs				QC 21 - SA - 70	21
					QC 21 - SA - 53	9-09

APR 08 2020

Part Op 100 - Weld per dwg A/R S.S. rod Batch: M139023 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect Descriptions: before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4- Weld D4672-1 blanking plates as per dwg

110 - QC9- Inspect visual per QSI004- Fusion Welds
 120 - QC5- Inspect part completeness to step on W/O
 125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings
 130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder coat
 140 - QC3- Inspect Part Finish
 150 - Assemble as per dwg - Pick Kit
 160 - QC5- Inspect part completeness to step on W/O
 170 - Identify as per dwg & Stock Location:
 180 - QC21- Final Inspection - Work Order Release

M#015147

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	S246180
D3913-1	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	S252319
D3913-15	Wide Handle Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	S230185
D3913-3	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	S252212
D3913-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	S242373
D3913-9	Hinge Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	S252343
D3916-041	Rib Assembly	2 pcs (2 ea)	100-Large Fab - Basket - 1	S262781
D3916-5	Light Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	S2629241/S253
D4016-1	Hinge Half, Base	3 pcs (3 ea)	100-Large Fab - Basket - 1	S257681
D4017-7	Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	S250092
D4017-9	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	S253400
D4020-11	End Mesh, Basket	2 pcs (2 ea)	100-Large Fab - Basket - 1	S253400
D4021-1	Handle Plate	3 pcs (3 ea)	100-Large Fab - Basket - 1	S253605
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	S260543
D4034-043	Fwd Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	S262350
D4672-1	Blanking Plate	2 pcs (2 ea)	100-Large Fab - Basket - 1	S256099
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	S236300
AN3-10A	BOLT	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	S249345-1
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	F86432
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	S016914
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	S248081
NAS1149F0332P	Washer (AN960-10L)	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	S216387
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	S241506
NAS1149FN832P	Washer (AN960-8)	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	S136368

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	42	0
	D3913-1	1	8	0
	D3913-15	1	11	0
	D3913-3	1	8	0
	D3913-7	2	28	0
	D3913-9	1	9	0
	D3916-041	2	4	0
	D3916-5	3	14	0
	D4016-1	3	60	0
	D4017-7	3	81	0
	D4017-9	2	14	0
	D4020-11	2	14	0
	D4021-1	3	55	0
	D4034-041	1	2	0
	D4034-043	1	3	0
	D4672-1	2	28	0
	M304EX0.75-16F	32	2,162	0
150-Handfinish - 4-1-Assembly-B4B	AN3-10A	6	424	0
	D2931	2	511	0
	D4021-5	2	33	0
	MS20600-AD4W3	2	670	0
	MS21042L3	6	2,243	0
	NAS1149F0332P	12	5,087	0
	NAS1149FN832P	2	5,345	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					